












Date: Tuesday, 16/12/2008 2:11:56 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 44119		
Estimate Number	: 10616		
P.O. Number	:	Part Number	: D265631
This Issue	: 16/12/2008 S.O. No. :	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 41736	Material	:
Written By	:	Due Date	: 30/12/2008 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 08.12.16</u>		
Comment	: Est: D 02.10.25 Re-format KJ Est Rev:E 06-06-12 Now On Waterjet JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M1010S20GA	1010/1025 SHEET	
			
		6.5 B8-12-18	
Comment: Qty.: 0.4095 sf(s)/Unit Total: 4.0950 sf(s) 1010/1025/A21/6aA .040"SHEET $104981 \times 3 = 1.5$ (M1010S20GA) $108275 \times 6 = 2.5$ Batch: <del>10289</del> $107906 \times 3 = 1.5$			
2.0	WATER JET	FLOW WATER JET	
			
Comment: FLOW WATER JET 1-Cut as per Dwg D2656 B8-12-18 Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary B8-12-18			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
		B8-12-18	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK 508/12/19 (12)			
5.0	BRAKE NC	NC BRAKE	
			
Comment: NC BRAKE Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326. Identify as D2656-31.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 16/12/2008 2:11:56 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 44119

Part Number: D265631

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/01/05 (12)

7.0

POWDER COATING

POWDER COATING



m-109648



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:35

OVEN TEMPERATURE:

320°

FINISH TIME:

3:05

FL 09/01/05

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ell



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-06-01 (12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: P-20

ell

09-06-01

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/07

Job Completion



MF 09-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

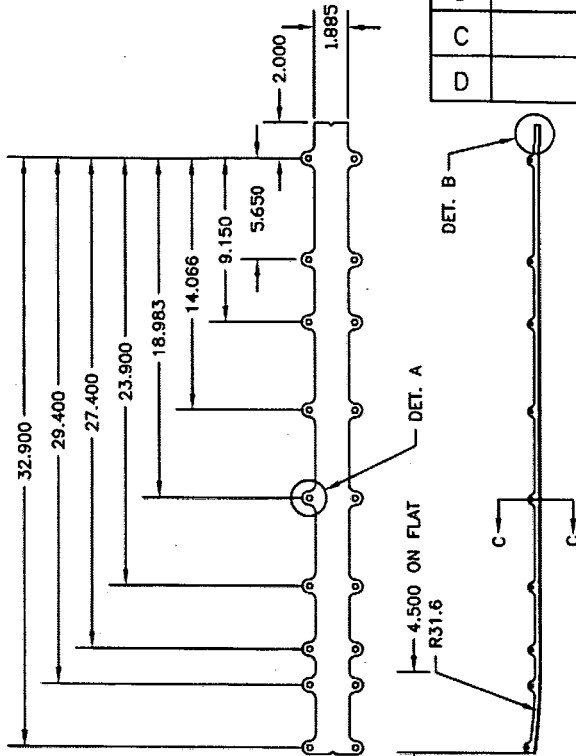
**NOTE:** Date & initial all entries



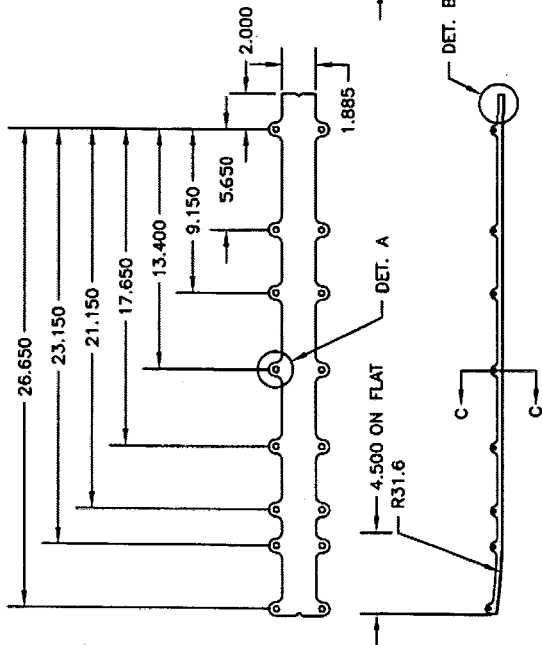
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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25		NEW ISSUE		
B	97:06:02		CHANGED TABS		
C	97:06:26		R31.6 WAS R19.5		
D	05.08.17		ENLARGE ALL HOLES TO IMPROVE FIT		

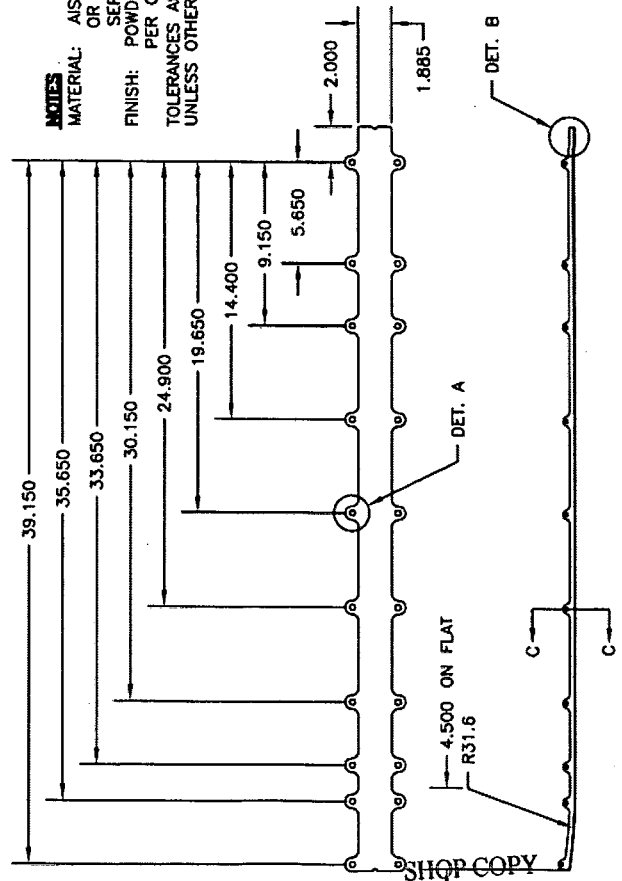
**D2658-13**



**D2658-11**



**D2658-15**



**NOTES:**  
 MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008  
 OR CSA G40-21, 38W/44W/50W/60W/70W  
 SERIES STEEL, 20 GAUGE (0.040 THICK)  
 FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)  
 PER QSI 005 4.3  
 TOLERANCES ARE PER DART QSI 018  
 UNLESS OTHERWISE NOTED

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 05-09-08

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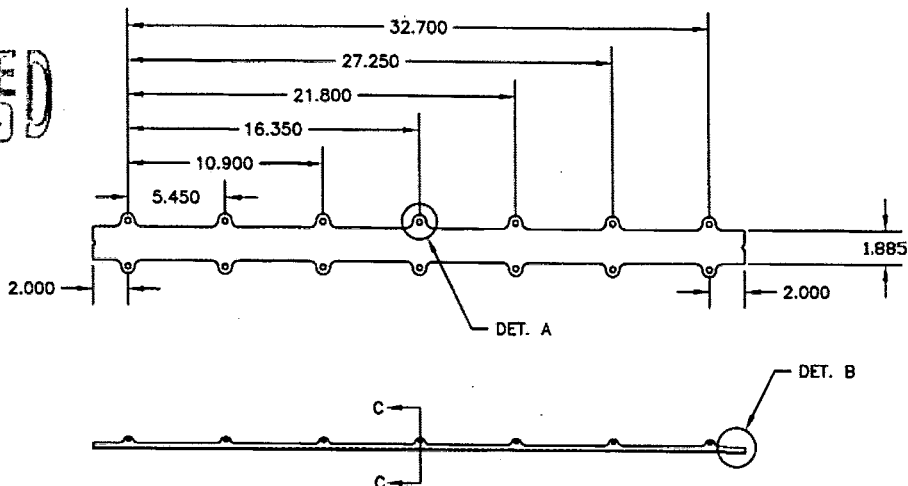
WORK ORDER  
 NO. 441165



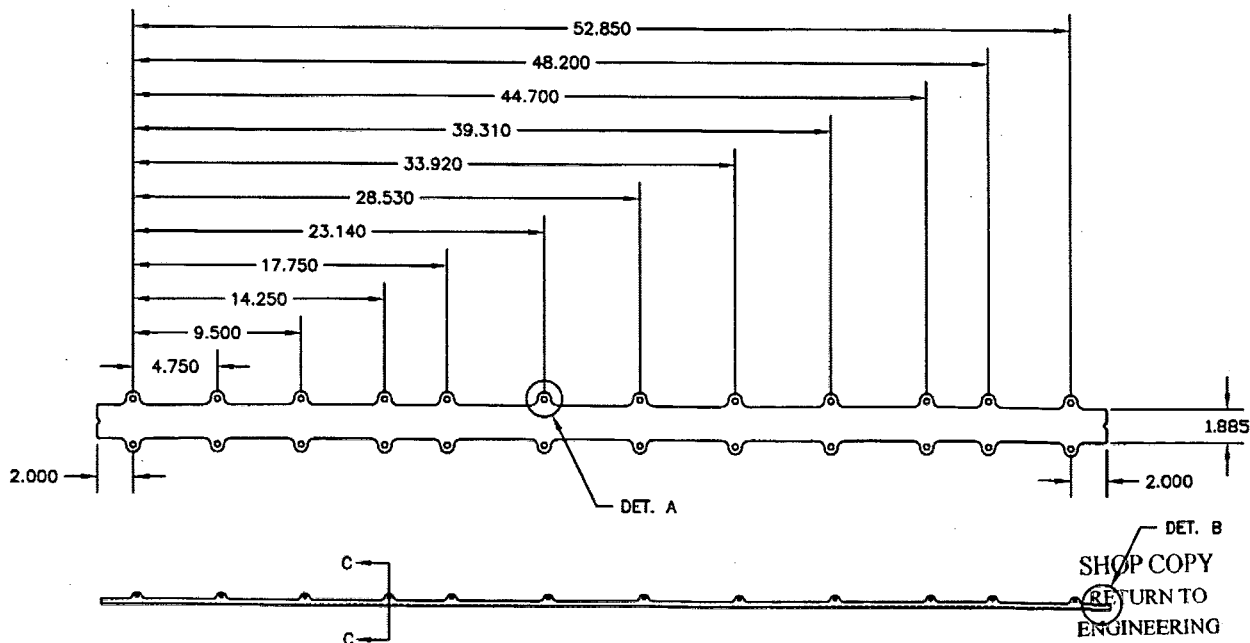
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

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**D2656-21**



**D2656-23**



**NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
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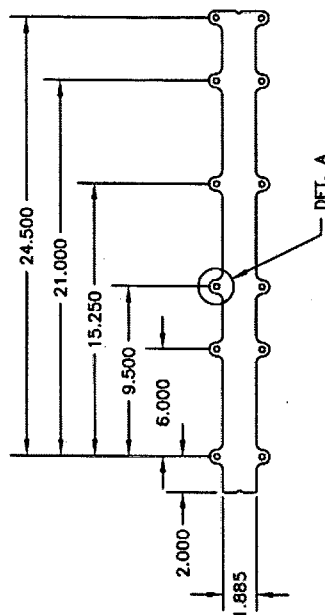
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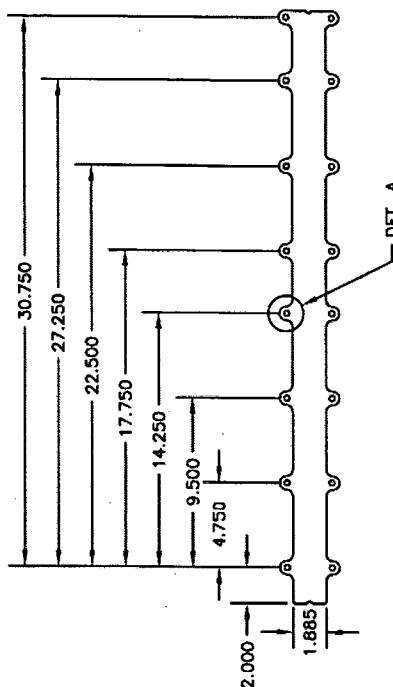


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

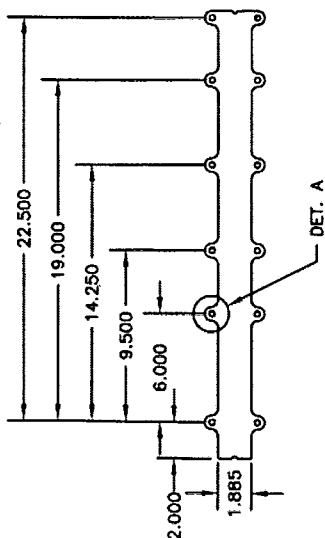


D2656-37

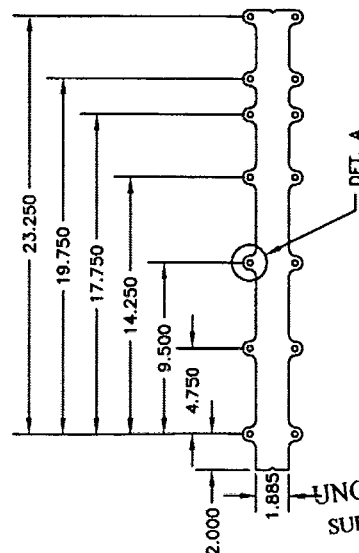


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D2656-35



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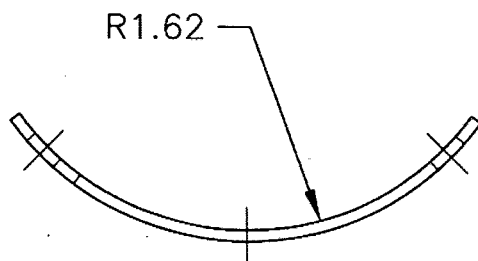
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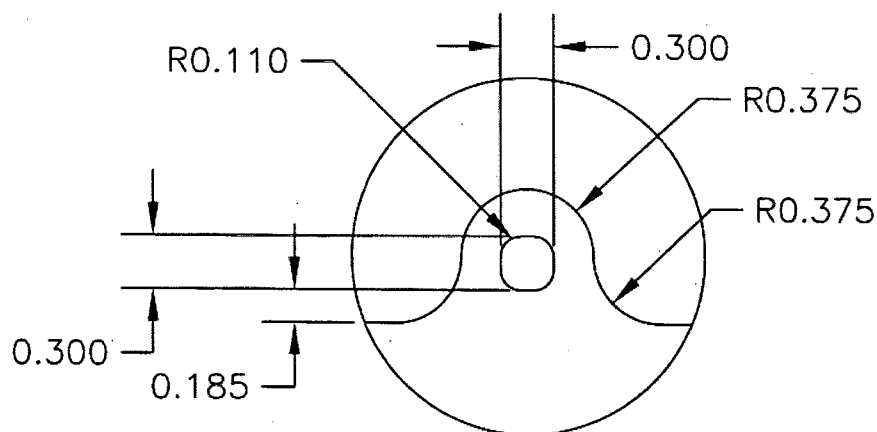
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

### SECTION C-C

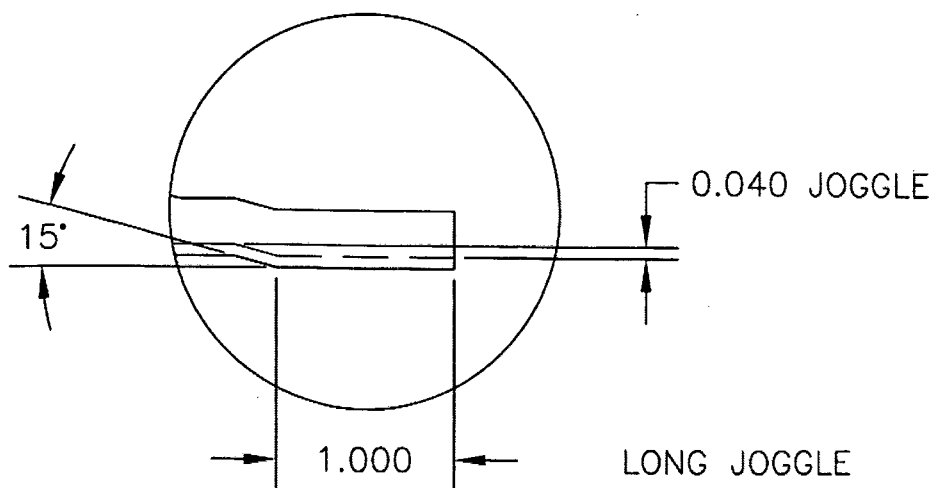


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### DETAIL A



### DETAIL B



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